

NCR-19-7563



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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C3-8-2-1

Job Sheet 190839



Part No: C3-8-2-1

Job Qty: 10 pcs

Part Name: Solenoid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/19/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-8-2 Rev 3 IPP Rev A 18.04.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Mill - 1	10 pcs	2/28/19	2/28/19	0.00	2.00	Conventional Mill - 1		
							Conventional Mill - 2		
110	QC 2	10 pcs	2/28/19	2/28/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S161522



Part: C3-8-2-1

Job No: 190839

Serial No/Batch: S161522

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Date: 03/12/19

Plex 2/19/19 7:17 AM Dart.lajeunesse.marie

120 QC 8	10 pcs	2/28/19	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	DAS 19-03-20
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
130 Packaging 3-1 - Stock - B4B 10 pcs		2/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS 20-03-20
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

2/19/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

140 QC 21 - SA	10 pcs	2/28/19	0.00 0.00	QC 21 - SA - 21	MAR 21 2019 DAS 21
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Manufacture as per dwg -1-USE C3-8-2-F1FIXTURE FOR DRILLING THE PIN HOLE (DT10451). 2-REMOVE COIL
 Descriptions: SPRING BEFORE DRILLING HOLE. 3-TURN SHAFT AS SHOWN IN FIXTURE BEFORE DRILLING (CLOCKWISE).
 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check - Engrave BATCH number using MARKTRONIC engraver as per DWG.
 130 - Identify as per dwg & Stock Location:
 140 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
152951-001	Solenoid	10 Ea (1 ea)	100-Conventional Mill - 1	5082463 GA208 GA208

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Conventional Mill - 1	152951-001	10	27	0

Part Specifications
Specifications could not be found.

Plex 2/19/19 7:17 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	190839
Description: Solenoid		Part Number:	C3-8-2-1
Inspection Dwg: Same as P/N	Rev: 3		Page 1 of 1

INSPECTION SHEET

[illegible]

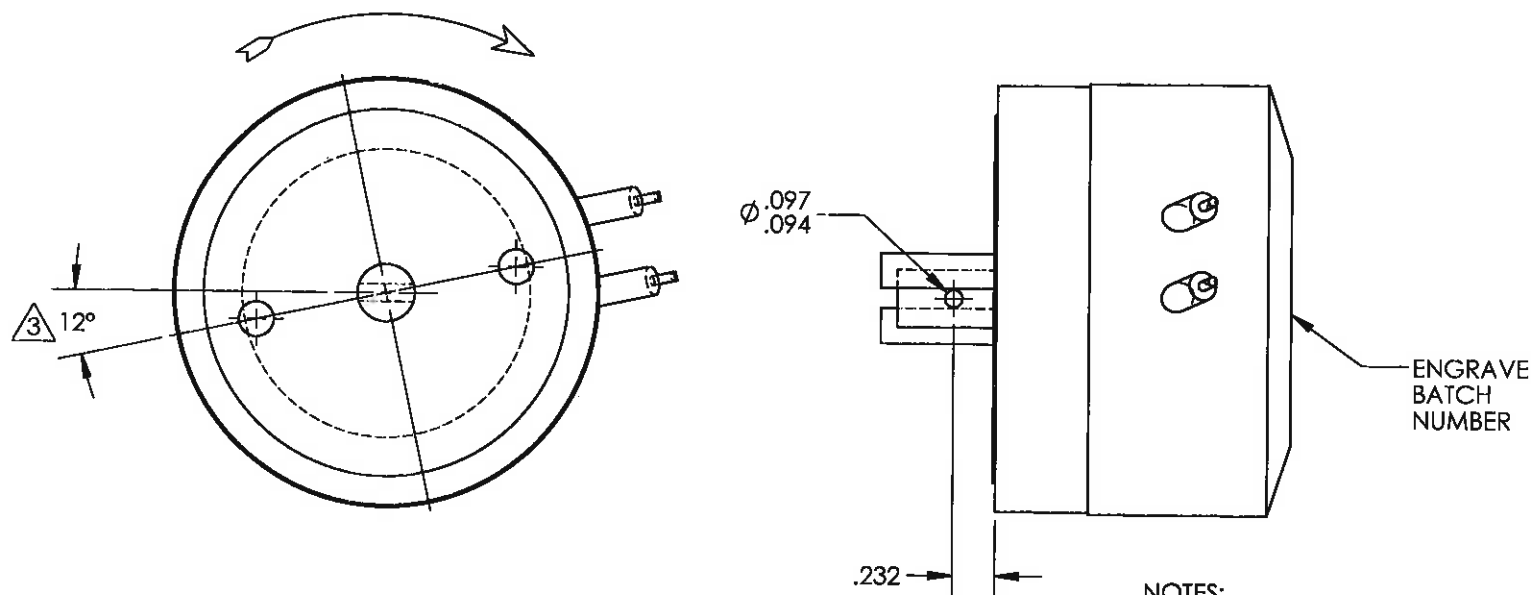
Measured by:	Checked by:	QC Inspector:
Date:	Date:	Date:

Engineering Approval: (If necessary)		Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	14 0195	C3-8-2-1 CH'D DIM WAS LIMITS Ø.0933-.0937 IS LIMITS Ø.094-.097. ADDED "CLOCKWISE" TO NOTE 3. CH'D NOTE 4 WAS PLACE BUSHING AND PIN IN PLACE AS SHOWN AFTER DRILLING IS INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING. ADDED ENGRAVE BATCH NUMBER NOTE.	10/23/2014	DPD	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
190839 MJS
1902-19

NOTES:

1. USE C3-8-2-F1 FIXTURE FOR DRILLING THE PIN HOLE.
2. REMOVE COIL SPRING BEFORE DRILLING HOLE.
3. TURN SHAFT AS SHOWN IN FIXTURE BEFORE DRILLING (CLOCKWISE).
4. INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING.



TITLE		SOLENOID ASSEMBLY	
DWG NO.		C3-8-2	
REV		3	
MATERIAL		DRAWN BY: CANAM	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED: D Weil	
.XXX ± .005		HEAT	
.XX ± .01		TREAT	
.X ± .1		FINISH	
FRACTIONS ± 1/8		SPEC	
ANGLES ± 5°		USED ON MODEL	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	1:1	DATE	12/19/2001
		SHEET 2 OF 4	

(C3-8-2-1)

SOLENOID WITH PINNED HOLE

at 24/1a



19-7563

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: 190839		DISPOSITION		DEPARTMENT/PROCESS			
Part No. C3-8-2-1		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☒	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: 19-03-20		Sequence #: 120		QTY Affected: 19		MRB (QSI042)	
Description Work Order Deviation				Disposition		19-03-20	
→ Solenoid casing has a dent in it due to poor handling/stocking process. → All solenoid are packaged individually and isolated from each other from the factory and are all inspected when they are received → They passed inspection when they came in				→ Scrap and destroy → Suggestion: Revise process of stocking solenoids to prevent further damage in the future		Completed By	
						D.A 19-03-20	
						Lead hand / Supervisor	
						D.A 19-03-20	
						QC / QA Coordinator	
						DAS 68 9-89	
						MAR 20 2019	
Root Cause		FAULT CATEGORY					
Operator ☐		☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong		
Manufacturing Process ☐		☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance		
Equip/Tooling ☐		☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing		
Handling/Presservation ☒		☐ Cracks	☒ Broken/Damage/Defect	☐ Weld	☐ Finish		
Material ☐		☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Product Improvement ☐		☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread		
Process Improvement ☐		☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up			
Human Factors ☐		Other/Details:					